



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2700-05

Job Sheet 172437



Part No: RBE350A94-2700-05

Job Qty: 1 pcs

Part Name: Main Rotor & Tail Rotor Rigging



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 10/29/18

Created By: Marie Lajeunesse

Type: Stock

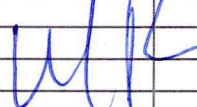
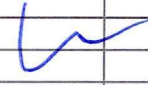
Description:

Note: RBE350A94-2700-05 REV.1 IPP REV:A 18.02.14 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/29/18		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	10/29/18		0.00	0.00	QC 5 - 10		 19.05.13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/29/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

- Packaging 3 - 7 - B4B
- Packaging 3 - 8 - B4B
- Packaging 3 - 9 - B4B
- Packaging 3 - 10 - B4B
- Packaging 3 - 11 - B4B
- Packaging 3 - 12 - B4B
- Packaging 3 - 13 - B4B
- Packaging 3 - 14 - B4B
- Packaging 3 - 15 - B4B
- Packaging 3 - 16 - B4B
- Packaging 3 - 17 - B4B
- Packaging 3 - 18 - B4B
- Packaging 3 - 19 - B4B
- Packaging 3 - 20 - B4B
- Packaging 3 - 21 - B4B
- Packaging 3 - 22 - B4B
- Packaging 3 - 23 - B4B
- Packaging 3 - 24 - B4B
- Packaging 3 - 25 - B4B
- Packaging 3 - 26 - B4B
- Packaging 3 - 27 - B4B
- Packaging 3 - 28 - B4B
- Packaging 3 - 29 - B4B
- Packaging 3 - 30 - B4B
- Packaging 3 - 31 - B4B
- Packaging 3 - 32 - B4B
- Packaging 3 - 33 - B4B
- Packaging 3 - 34 - B4B
- Packaging 3 - 35 - B4B
- Packaging 3 - 36 - B4B

140 QC 21 - SA 1 pcs 10/29/18 0.00 0.00

QC 21 - SA - 21
QC 21 - SA - 70

Part Op 110 - (Small Fab) PACK TOOLS AS PER DWG
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	110-Small Fab - 1	5108536
7189K31	Cable Ties Black	6 Ea (6 ea)	110-Small Fab - 1	5038430
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	110-Small Fab - 1	5094608
NAS1756-12	Remove Before Flight	6 Ea (6 ea)	110-Small Fab - 1	5134216
RBE350A94-2700-05-13	Tool Cushion	1 Ea (1 ea)	110-Small Fab - 1	5056910
RBE350A94-2704-00	Pedals Locking Tool	1 pcs (1 ea)	110-Small Fab - 1	5116133
RBE350A94-2706-00	Rigging Pin Set	1 pcs (1 ea)	110-Small Fab - 1	5121872
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 pcs (1 ea)	110-Small Fab - 1	5159534
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 pcs (1 ea)	110-Small Fab - 1	5157817
RBE350A94-3700-C	Swashplate Immobilizing Tools Adjustable Brace	1 pcs (1 ea)	110-Small Fab - 1	5131658
RBE350A94-3701-00-01	7° Main Rotor Rigging Tool	1 pcs (1 ea)	110-Small Fab - 1	5159531

↑
00-01 = 70

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	10164	1	4	0
	7189K31	6	773	0
	9052000	4	87	0
	NAS1756-12	6	486	0
	RBE350A94-2700-05-13	1	2	0
	RBE350A94-2704-00	1	11	0
	RBE350A94-2706-00	1	10	0
	RBE350A94-2708-01	1	3	0
	RBE350A94-3700-A	1	0	0
	RBE350A94-3700-C	1	3	0
	RBE350A94-3701-00	1	10	0
Part Specifications				
Specifications could not be found.				

Plex 1/23/19 11:40 AM Dart.Hadley.Shannon



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Hawkesbury, ON
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Tel (613) 632-5200

RBE350A94-2700-05

Job Sheet 172437



Part No: RBE350A94-2700-05

Job Qty: 1 ea

Part Name: Main Rotor & Tail Rotor Rigging



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 3/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: RBE350A94-2700-05 REV.1 IPP REV:A 18.02.14 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/22/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		3/23/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs		3/23/18	0.00	0.00	QC5		
130	Packaging	1 pcs		3/23/18	0.00	0.00	Packaging3-1		
140	QC21-SA	1 Ea		3/23/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - PACK TOOLS AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	90-Start up Operation	
7189K31	Cable Ties Black	6 Ea (6 ea)	90-Start up Operation	
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	90-Start up Operation	
NAS 1756-12	Remove Before Flight	6 (6 ea)	90-Start up Operation	
RBE350A94-2700-05-13	Tool Cushion	1 (1 ea)	90-Start up Operation	
RBE350A94-2704-00	Pedals Locking Tool	1 Ea (1 ea)	90-Start up Operation	
RBE350A94-2706-00	Rigging Pin Set	1 Ea (1 ea)	90-Start up Operation	
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 Ea (1 ea)	90-Start up Operation	
RBE350A94-3700-A	Swashplate Immobilizing Tool Long Brace	1 Ea (1 ea)	90-Start up Operation	
RBE350A94-3700-C	Swashplate Immobilizing Tool Adjustable Brace	1 Ea (1 ea)	90-Start up Operation	
RBE350A94-3701-00	Main Rotor Rigging Tool	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	10164	1	0	0
	7189K31	6	1,000	0
	9052000	4	60	0
	NAS 1756-12	6	0	0
	RBE350A94-2700-05-13	1	0	0
	RBE350A94-2704-00	1	0	0
	RBE350A94-2706-00	1	0	0
	RBE350A94-2708-01	1	0	0
	RBE350A94-3700-A	1	0	0
	RBE350A94-3700-C	1	0	0
	RBE350A94-3701-00	1	22	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Part Specifications
Specifications could not be found.

Plex 2/16/18 12:32 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

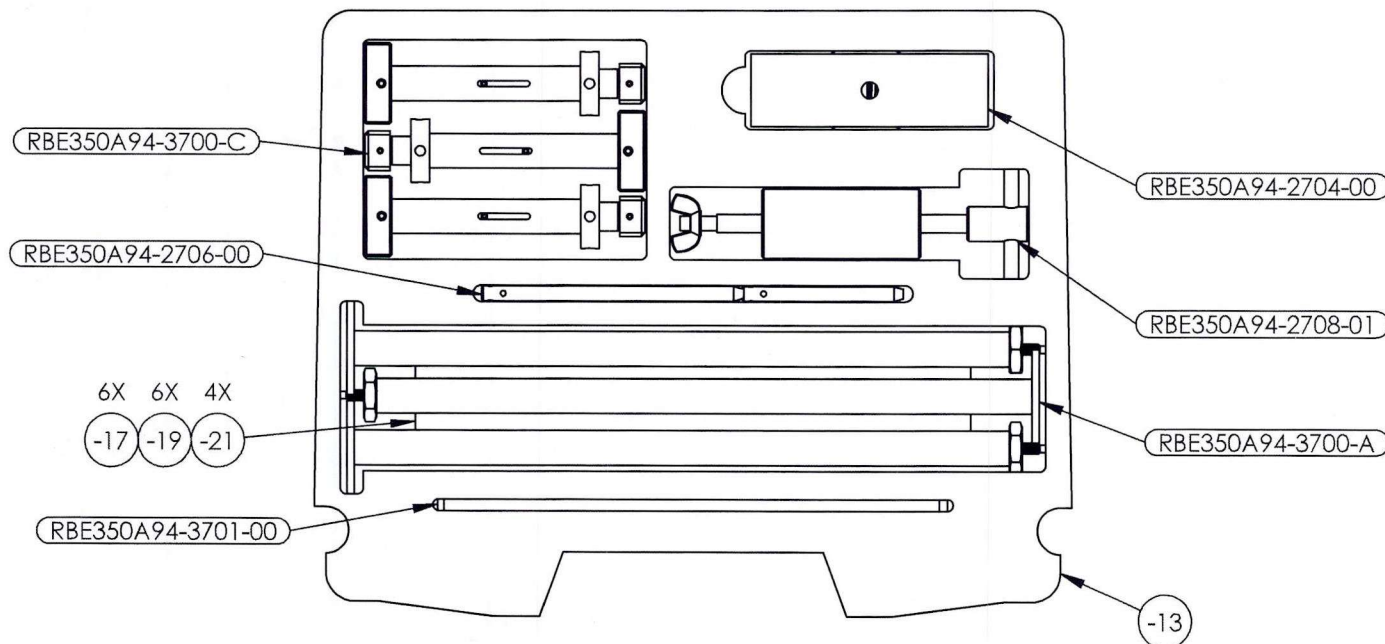
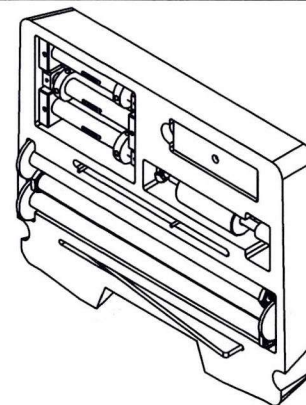
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CH'D T/N WAS RBEA94-2700-05 IS RBE350A94-2700-05.	6/19/2013	BIM	RW
1	15-0164	UPDATED KIT T/N'S WAS RBEA94-2704-00 IS RBE350A94-2704-00, WAS RBEA94-2706-00 IS RBE350A94-2706-00, WAS RBEA94-2708-01 IS RBE350A94-2708-01, WAS RBEA94-3700-A IS RBE350A94-3700-A, WAS RBEA94-3700-C IS RBE350A94-3700-C, WAS RBEA94-3701-00 IS RBE350A94-3701-00.	7/15/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172437
MLJ
18-02-16

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	DART AEROSPACE MAIN ROTOR & TAIL ROTOR RIGGING KIT (NO AUTO PILOT)		
				1	JAMMING TOOL, PEDALS		RBE350A94-2704-00	1			
				1	RIGGING PIN SET		RBE350A94-2706-00	1	DWG NO.	RBE350A94-2700-05	REV 1
				1	T/R BLADE LOCK FIXTURE		RBE350A94-2708-01	1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1		
				1	SWASHPLATE IMMOBILIZING TOOL LONG BRACE		RBE350A94-3700-A	1			
				1	SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE		RBE350A94-3700-C	1	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
				1	M/R RIGGING TOOL		RBE350A94-3701-00	1			
		B/O	-13	1	TOOL CUSHION	Y20 BLACK	3-1/4 X 13 X 16-3/8 I.R. SPECIALTIES	2	DRAWN BY: PERRITT APPROVED: D. Weill HEAT TREAT FINISH SPEC		
		B/O	-15	1	TOOL CASE	BLACK PLASTIC	PLANO GUN GUARD #10164	N/S			
		B/O	-17	6	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1	USED ON MODEL EUROCOPTER AS350/355		
		B/O	-19	6	BEADED CABLE TIE	NYLON	5-1/2 (MCMaster-CARR #7189K31)	1			
		B/O	-21	4	ELASTIC RETAINERS W/HOOKS	BUNGEE CORD	Ø1/4 X 10	1	SCALE 1:4	DATE 1/11/2010	SHEET 1 OF 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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